

Date: Thursday, 4/12/2007 9:08:25 AM  
 User: Kim Johnston

## Process Sheet

|                       |                                       |                  |               |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : GUIDE       |
| Job Number            | : 31761                               |                  |               |
| Estimate Number       | : 11073                               |                  |               |
| P.O. Number           | : N/A                                 | Part Number      | : D31373      |
| This Issue            | : 4/12/2007                           | S.O. No.         | : N/A         |
| Prsh Rev.             | : NC                                  | Drawing Number   | : D3137 REV D |
| First Issue           | : N/A                                 | Project Number   | : N/A         |
| Previous Run          | : 29830                               | Drawing Revision | : D           |
| Written By            | : <u>JMK</u>                          | Material         | : N/A         |
| Checked & Approved By | : <u>DK</u> 07/04/12                  | Due Date         | : 5/5/2007    |
| Comment               | : Est Rev:A 02.05.29 New Issue NG     | Qty:             | 12            |
| Um:                   |                                       | Um:              | Each          |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :   |                            |
|---------|-----------------------|---|----------------------------|
| 1.0     | MDELRLINB075X1250     | Delrin Bar  |                            |
|         |                       | Comment: Qty.: 0.0831 f(s)/Unit Total : 0.9967 f(s)<br>Matl:Black Delrin bar 1.250" x .750"<br>( ref DART spec. M-DELRIN-B )<br>Batch: <u>14535</u> | <u>07/04/15</u>            |
| 2.0     | BAND SAW              | BAND SAW  |                            |
|         |                       | Comment: BAND SAW<br>Cut Blanks.Bank size: 1.250" x .750" x .950" long  | <u>07/04/15</u>            |
| 3.0     | HAAS1                 | HAAS CNC VERTICAL MACHINING #1  |                            |
|         |                       | Comment: HAAS CNC VERTICAL MACHINING #1<br><br>1-Machine as per Folio FA242 & Dwg D3137   | <u>07/04/15</u>            |
|         | 2-Deburr              |   | <u>07/04/15</u>            |
| 4.0     | QC2                   | INSPECT PARTS AS THEY COME OFF MACHINE  |                            |
|         |                       | Comment: INSPECT PARTS AS THEY COME OFF MACHINE   | <u>07/04/15</u>            |
| 5.0     | QC8                   | SECOND CHECK  |                            |
|         |                       | Comment: SECOND CHECK   | <u>07/04/18</u> <u>471</u> |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/04/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:08:25 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 31761

Part Number: D31373

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                              |              |             |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD           | Work Order:  | 31761       |
| Description: Guide           | Part Number: | D3137-3     |
| Inspection Dwg: D3137 Rev: E |              | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

|              |            |             |           |                     |     |
|--------------|------------|-------------|-----------|---------------------|-----|
| Measured by: | <i>GML</i> | Audited by: | <i>BG</i> | Prototype Approval: | N/A |
| Date:        | 07/04/15   | Date:       | 6/1/15    | Date:               | N/A |

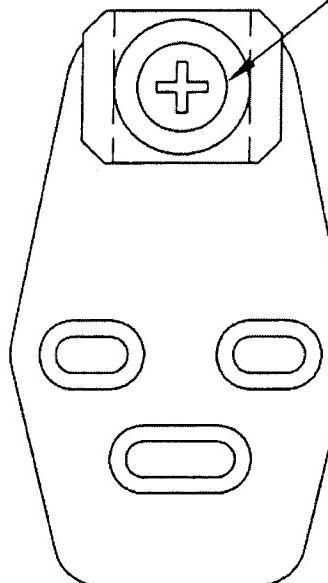
| Rev | Date     | Change  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   | 03.11.27 | New Issue                                       | KJ/RF      |          |
| B   | 04.11.12 | 0.175 was 0.145 & Ø0.65 x 100° was Ø0.75 x 100° | KJ/JLM     |          |
| C   | 06.03.15 | Dwg Rev update                                  | KJ/JLM     | ✓ ✓      |



|                     |                      |   |                        |
|---------------------|----------------------|---|------------------------|
| DESIGN<br>DS        | DRAWN BY<br>RF       | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>#</i> | APPROVED<br><i>#</i> | DRAWING NO.<br>D3137                              | REV. E<br>SHEET 1 OF 5 |
| DATE<br>05.11.23    |                      | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:1           |
| A                   | 02.04.17             | NEW ISSUE   |                        |
| B                   | 03.01.16             | ADD RIDGES; ADD MAT'L PROP.                       |                        |
| C                   | 03.08.15             | ADD -043  |                        |
| D                   | 04.11.03             | RE-DESIGN D3137-5; CHANGE DIMS                    |                        |
| E                   | 05.11.23             | ADD -045  |                        |

RELEASED

05.12.09



MS24694-S101 SCREW  
D3137-5 WASHER  
D3137-3 GUIDE  
INSTALL ON SAME SIDE AS C'SINKS  
(OPPOSITE SIDE FROM RIDGES)

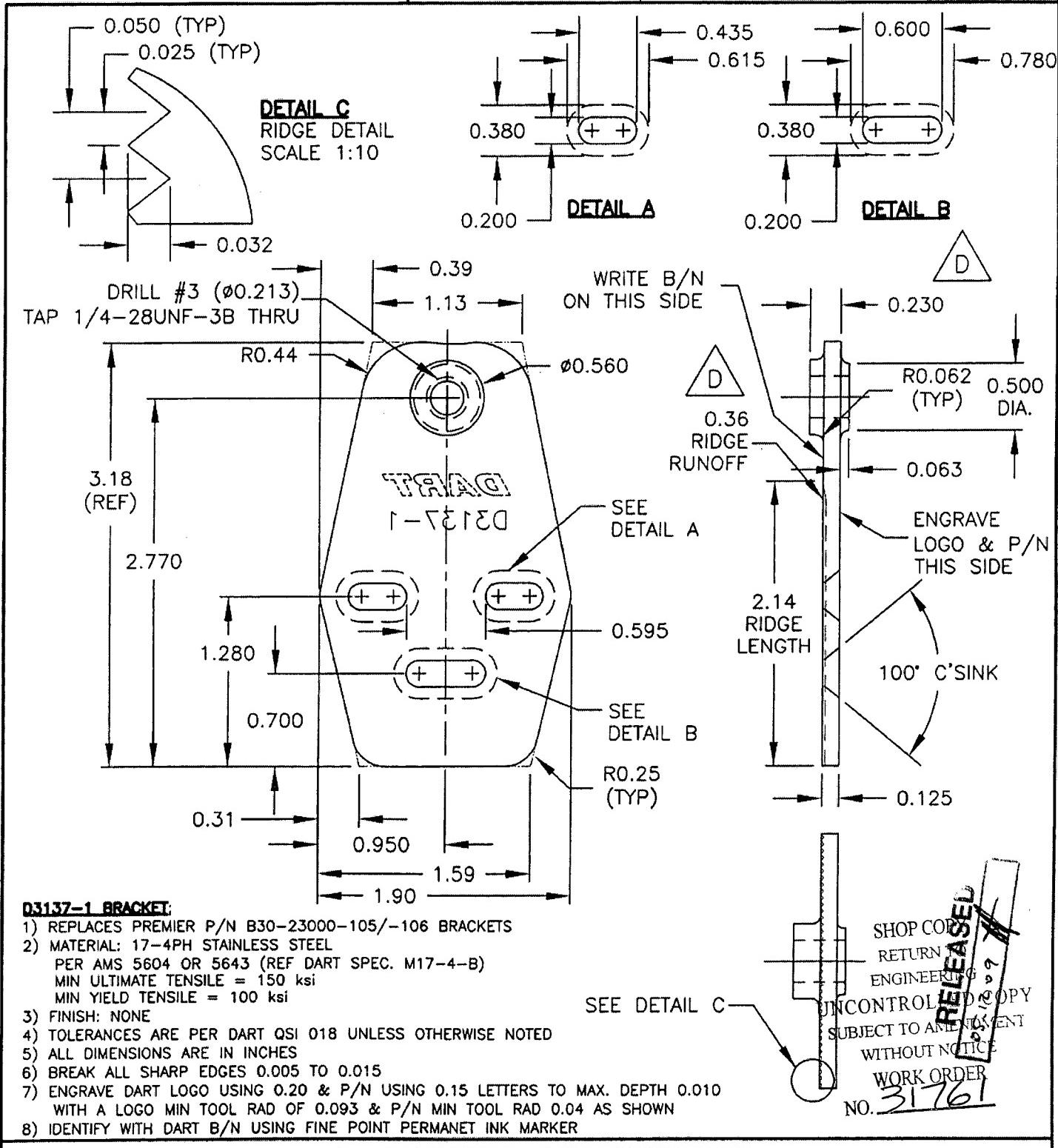
D3137-1 BRACKET (-041 SHOWN)  
OR  
D3137-7 BRACKET (-043 SIMILAR)  
OR  
D3137-9 BRACKET (-045 SIMILAR)

D3137-041 BRACKET ASSEMBLY (SHOWN)  
D3137-043 BRACKET ASSEMBLY (SIMILAR)  
D3137-045 BRACKET ASSEMBLY (SIMILAR)

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| CHECKED<br><b> </b>     | APPROVED<br><b> </b>  | DRAWING NO.<br><b>D3137</b>                       | REV. E<br>SHEET 2 OF 5 |
| DATE<br><b>05.11.23</b> |                       | TITLE<br><b>BRACKET ASSEMBLY</b>                  | SCALE<br><b>1:1</b>    |

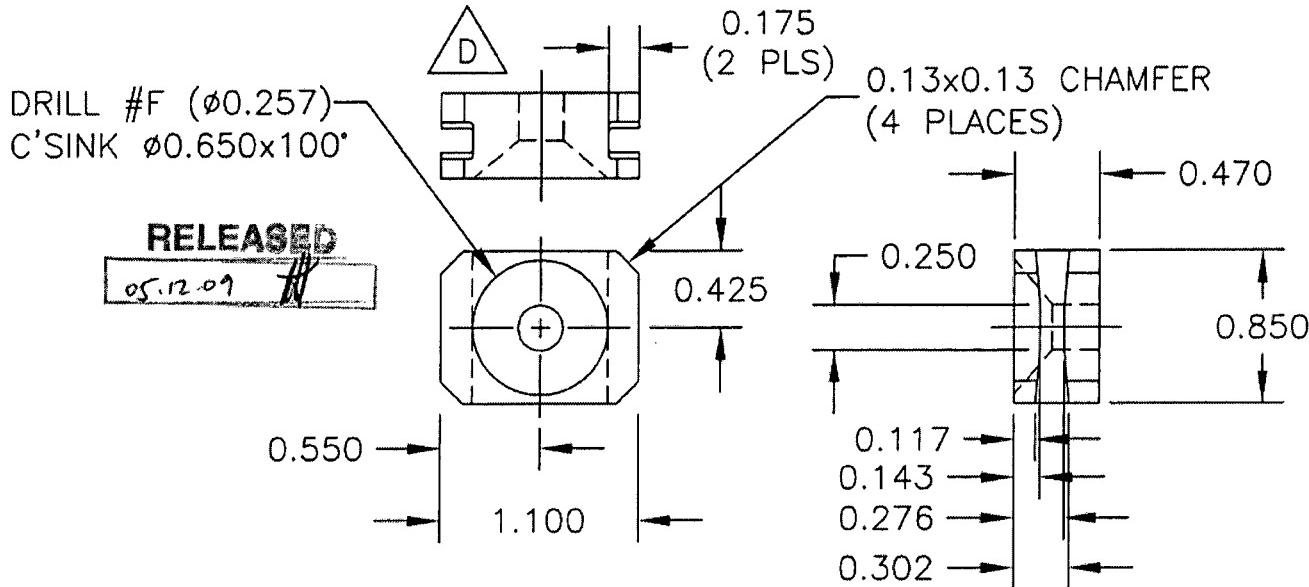


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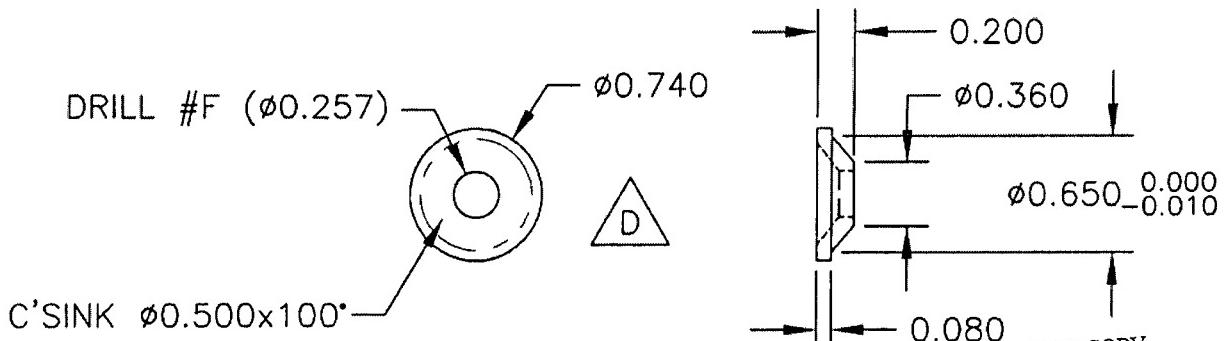


|                              |                               |   |                        |
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| DATE<br>05.11.23             |                               | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:1           |



### D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015



### D3137-5 WASHER

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

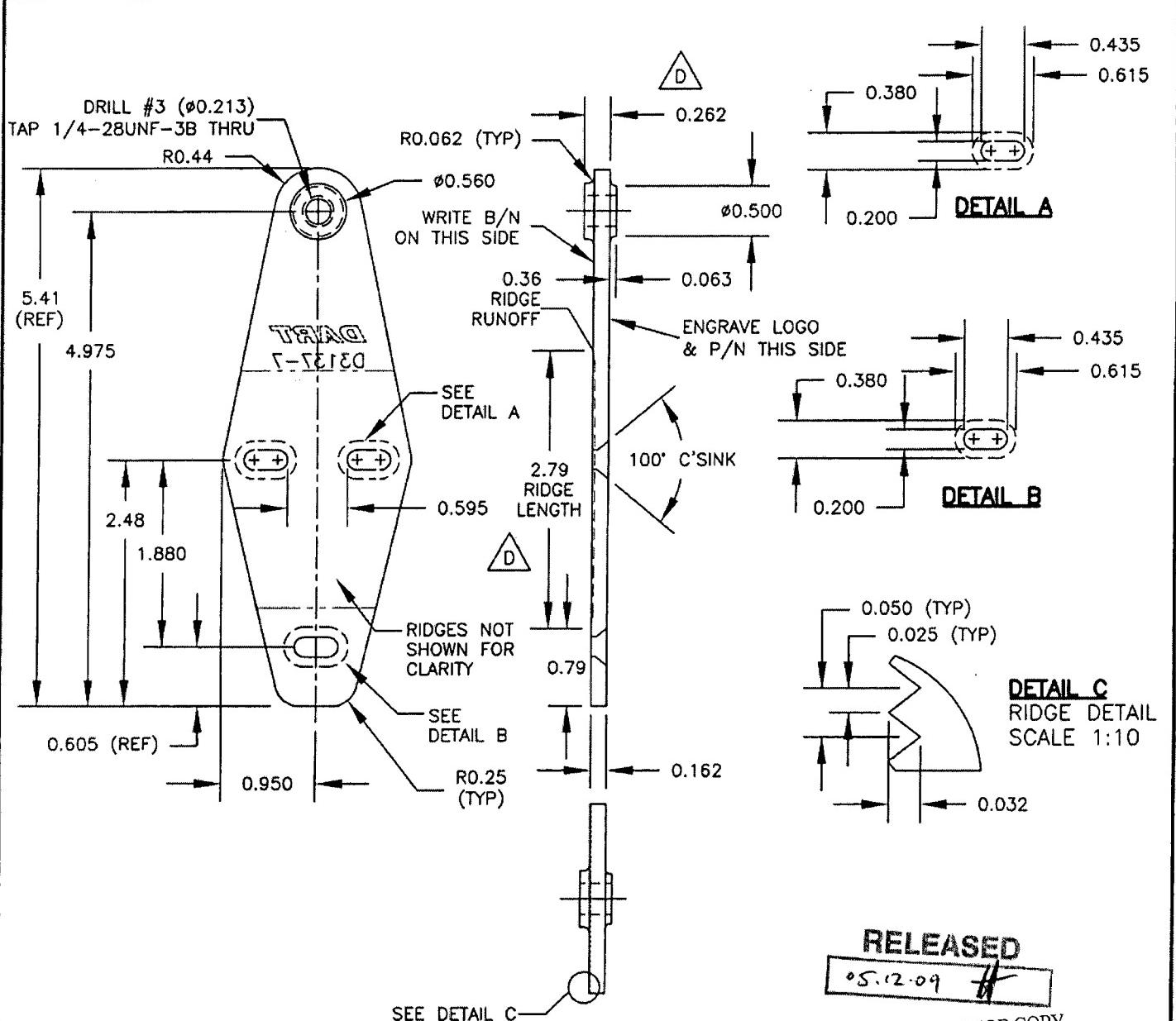
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3137  |
| DATE<br>05.11.23              |                                | REV. E<br>SHEET 4 OF 5<br>TITLE<br>BRACKET ASSEMBLY<br>SCALE<br>2:3 |



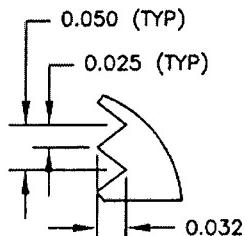
**D3137-7 BRACKET:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010 WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

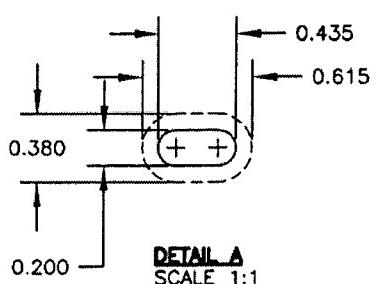
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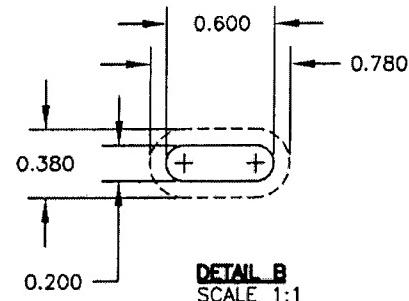
|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3137                              | REV. E<br>SHEET 5 OF 5 |
| DATE<br>05.11.23              |                                | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:2           |



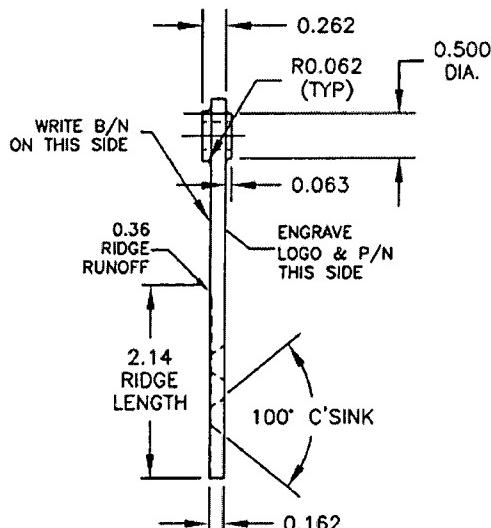
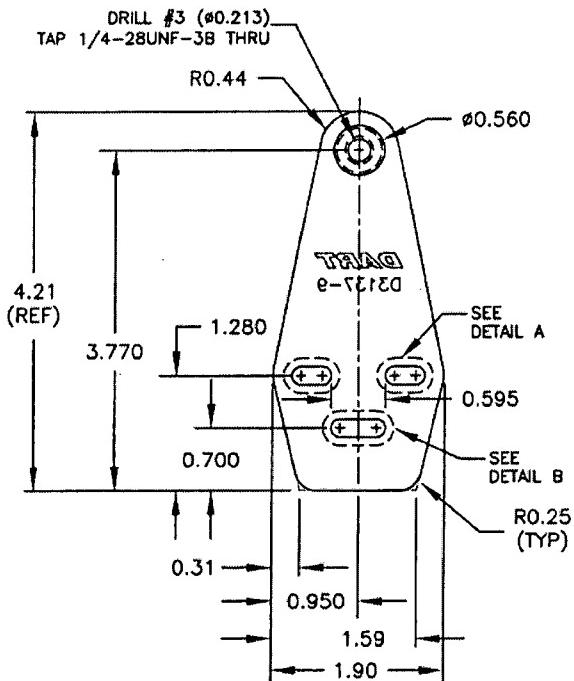
**DETAIL C**  
RIDGE DETAIL  
SCALE 1:20



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1



**D3137-9 BRACKET:**

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES .005 TO .015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010  
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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